

Work Order ID 131946

131946

Tuesday, April 21, 2015 1:57:44 PM

Item ID: D3965-4 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearing, Spherical
 Start Date: 4/24/15 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 4/24/15 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-04-22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3965	B

100 0.00

100

Purchasing Memo 0.00

Purchasing PURCHASING

Issue P/O: 28245
 Purchase Part Number: 63215K52
 Possible Supplier: McMaster
 Material release note is required

CY 15/04/23 10

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging Memo 0.00

Packaging

10X SP 15-04-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Page 2

Item ID: D3965-4 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearing, Spherical
Start Date: 4/24/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/24/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									DAS
QC	Memo	0.00							38
Quality Control									9-89
									APR 24 2015
130	Identify as per dwg & Stock Location: ST-013	0.00							
130									DAS
Packaging	Memo	0.00							66
Packaging									9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

10
840
APR 27 2015 **MCJ 1504-27**
MCJ 1504-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 131946

131946

Parent Item: D3965-4

D3965-4

Parent Item Name: Bearing, Spherical

Start Date: 4/24/15

Required Date: 4/24/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
12.03.06 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
63215K52		Purchased	No			110	Each	0.0000	1	10			
63215K52									**				
Bearing Spherical													

10x 8075-01-24.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

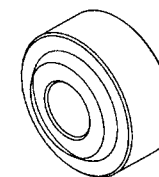
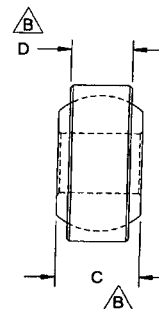
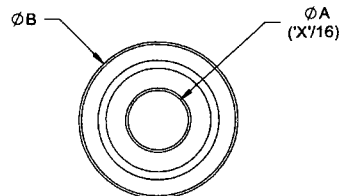


QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

SPECIFICATION CONTROL DRAWING



D3965-X BEARING, SPHERICAL

WHERE 'X' IS I.D. IN 1/16" OF AN INCH
EG Ø 1/4" (4/16") I.D. BEARING = D3965-4

DART P/N	SUPPLIER	SUPPLIER P/N	A	B	C	D	STATIC RADIAL LOAD CAP. lbs
D3965-3	McMASTER-CARR	63215K31	0.188	0.563	0.281	.219	3,975
D3965-4	McMASTER-CARR	63215K52	0.250	0.656	0.344	0.250	6,040
D3965-5	McMASTER-CARR	63215K53	0.313	0.750	0.375	0.281	8,750
D3965-6	McMASTER-CARR	63215K34	0.375	0.813	0.406	0.313	10,540

NOTES:

- 1) MATERIAL: 440C STAINLESS STEEL WITH PTFE LINER
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

UNCONTROLLED COPY
131946 MLJ
1504-22

RELEASED
2012-03-02

B	CORRECT LETTER DESIGNATED C & D (ZN C4-1) PER PAR11-151	RF	12.01.10
A	NEW ISSUE	RF	09.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3965 TITLE BEARING, SPHERICAL SCALE NTS	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	REV. B SHEET 1 OF 1	
DATE	12.01.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28245**

Purchase Order Date 4/23/2015

PO Print Date 4/23/2015

Page Number 1 of 3

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	9610K17 AS PER DWG D3619 REV. A B131910	GROMMET	4/24/2015 Yes 4/24/2015		4.00 ✓ Each	\$12.90	\$51.60
Line Total:							\$51.60
2	63215K52 AS PER DWG D3965 REV. B B131946	Bearing Spherical	4/24/2015 Yes 4/24/2015		10.00 ✓ Each	\$15.62	\$156.20 ✓
Line Total:							\$156.20
3	71400-45	6264K72HALF LINK	4/24/2015 Yes 4/24/2015		2.00 ✓ Each	\$7.80	\$15.60

Note:

4/23/2015

SP 15-04-23

C215/04/24

SP 15-04-24

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Jessi

Purchase Order
PO28245
Order Placed By
Chantal Lavoie

McMaster-Carr Number
2485646-01

Page 1 of 1
04/23/2015

Line	Product	Ordered	Shipped
1	9610K17 MIL Spec. Two-Piece Grommet Kit, Trade Size 1, 0.687" OD, 48 Grommets with Teeth Washers Your Part Number: B131910	4 Each	4
2	63215K52 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Ball Thick Your Part Number: B131946	10 Each	10 <i>SP15-04-24</i>
3	6264K72 ANSI #40-Stainless Steel Add-and-Connect Link for 304 Stainless Steel, Highly Corrosion-Resistant Roller Chain Your Part Number: 71400-45	2 Each	2
4	60355K42 Steel Ball Bearing--ABEC-1, Double Shielded, No. R3 for 3/16" Shaft Diameter, 1/2" OD Your Part Number: 71725-45	2 Each	2
5	7196K31 Straight-Blade, Three-Blade Male Plug, NEMA 5-15 Your Part Number: 71725-45	4 Each	4
6	7494T85 Shop-Vac Vacuum Accessory, 2-1/2" Diameter X 3" Plastic Round Brush Your Part Number: 72000-45	1 Each	1
7	4719A438 Sanding Sleeve, Multipurpose, 120 Grit, 3/4" Inside Diameter, 1" Long, Packs of 25 Your Part Number: 71500-11	8 Packs	8

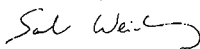
McMaster-Carr Supply Company 200 Aurora Industrial Pkwy Aurora, OH 44202-8087 USA Phone: 330-995-5500 Fax: 330-995-9600 E-Mail: cle.sales@mcmaster.com Employer Identification Number (EIN): 36-1458720		Invoice: 28481919 Purchase Order: PO28245 Release: McMaster-Carr Number: 2485646-01		ORIGINAL COMMERCIAL INVOICE CERTIFICATE OF ORIGIN	
Ultimate Destination: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Shipped: 23-Apr-2015		FOB: ORIGIN	
		Shipper's Export Declaration (SED): NO EEI 30.36			
Intermediate Consignee:		Bill To: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada			
		Tax Number:			
Forwarding Agent:		Billing Attention: Shipping Jessi Attention: Contact:			

Line	Description	Qty & Unit	Unit Price	Extension
1	9610K17 MIL Spec. Two-Piece Grommet Kit, Trade Size 1, 0.687" OD, 48 Grommets with Teeth Washers B131910 Country of Origin: United States Schedule B #: 820559 ECCN #: EAR99 NLR	4 EA	\$12.90	\$51.60
2	63215K52 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Ball Thick B131946 Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	10 EA	\$15.62	\$156.20
3	6264K72 ANSI #40-Stainless Steel Add-and-Connect Link for 304 Stainless Steel, Highly Corrosion-Resistant Roller Chain 71400-45 Country of Origin: Japan Schedule B #: 731519 ECCN #: EAR99 NLR	2 EA	\$7.80	\$15.60
4	60355K42 Steel Ball Bearing--ABEC-1, Double Shielded, No. R3 for 3/16" Shaft Diameter, 1/2" OD 71725-45 Country of Origin: Japan Schedule B #: 848210 ECCN #: 1C999 NLR	2 EA	\$6.56	\$13.12

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